

Work Order ID 158435***158435***

Page 1

Wednesday, March 22, 2017 2:17:51 PM

Item ID: D5194-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 3/27/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 6.00

6

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

DAS
21
9-89

Date: MAR 22 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5194

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.31

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

Ce PR 17/03/25

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Ce PR 17/03/25

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Ce

DAS
38
9-89
MAR 27 2017

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1
NC BRAKE

0.00

130

HandFinish

Memo

0.44

Hand Finishing

(Handwritten: X6, 20170416, BB)

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

(Handwritten: 6)
DAS 38 9-89

APR 06 2017

150

Identify as per dwg & Stock Location: *8T220*

0.00

150

Packaging

Memo

0.00

Packaging

(Handwritten: 6x)
DAS 26 9-89

APR 06 2017

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158435

Page 3

Wednesday, March 22, 2017 2:17:51 PM

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N900040100

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Required Date: 3/29/2017 Req'd Qty: 6.00

6

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan: Date:

Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

DAS
21
9-89

APR 06 2017

17/4/10 J

Picklist Print

Wednesday, March 22, 2017 2:17:56 PM

Page 1

Work Order ID: 158435

158435

Parent Item: D5194-1

D5194-1

Parent Item Name: Doubler

Start Date: 3/27/2017

Required Date: 3/29/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased			No	100	sf	156.9536	0.652	4.117895			

M6061T6S 032

6061-T6 Sheet 0.032"

**

PR 17/03/25

Location

Loc Qty

Loc Code

MAT021

156.953563

m131352

5.320037

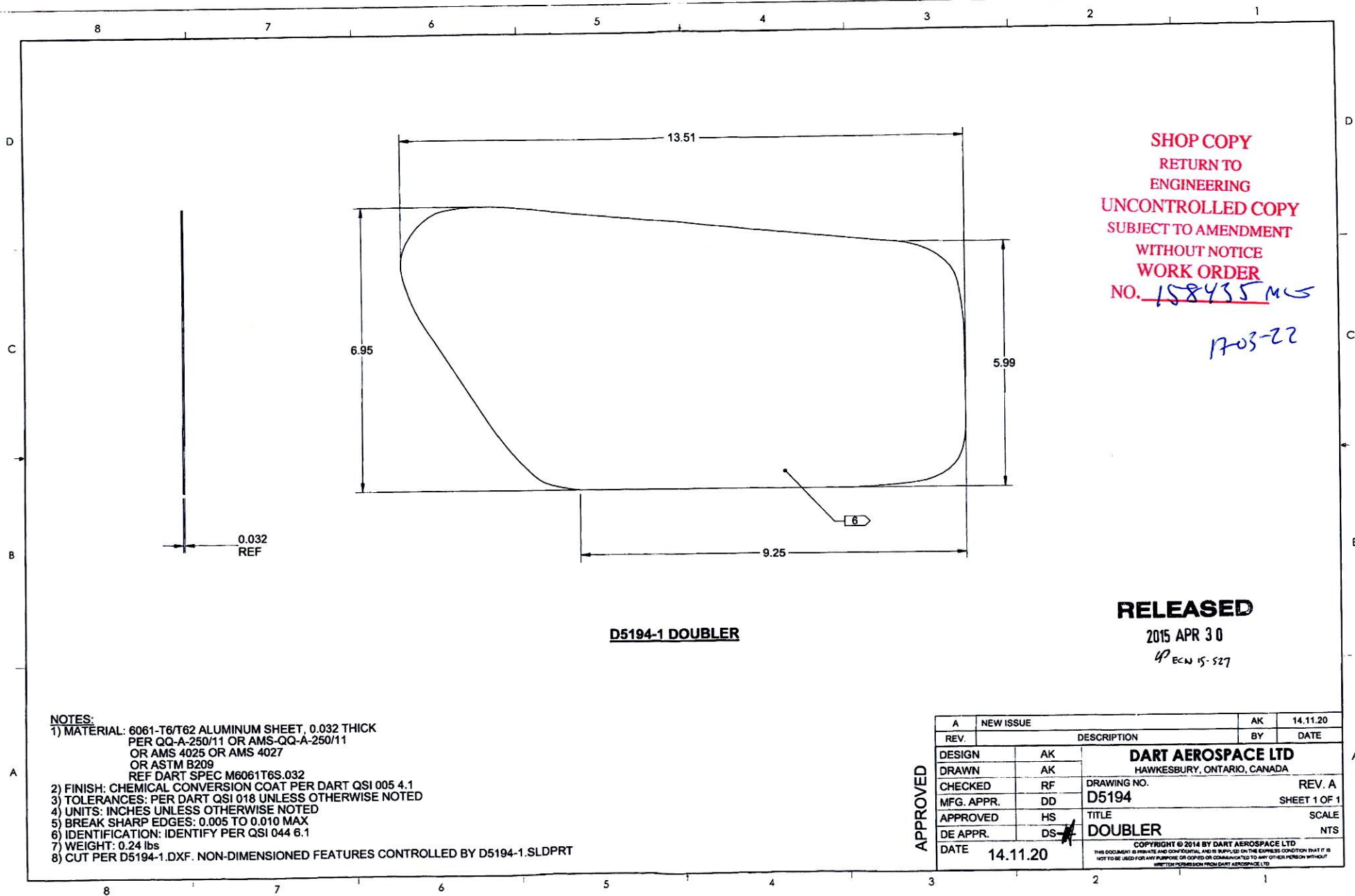
m135724

55.633526

m136942

96

4.6



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158435 M5
1703-22

D5194-1 DOUBLER

RELEASED
2015 APR 30
47 ECN 15-527

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.24 lbs
 - 8) CUT PER D5194-1.DXF. NON-DIMENSIONED FEATURES CONTROLLED BY D5194-1.SLDPRT

APPROVED

APPROVED

A		NEW ISSUE		AK	14.11.20	
REV.		DESCRIPTION			BY	DATE
DESIGN		AK		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		AK				
CHECKED		RF		DRAWING NO.		REV. A
MFG. APPR.		DD		D5194		SHEET 1 OF 1
APPROVED		HS		TITLE		SCALE
DE APPR.		DS		DOUBLER		NTS
DATE		14.11.20		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		